

Work Order ID 158515

Friday, March 24, 2017 11:06:46 AM

158515

Page 1

Item ID: D3589-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Latch Assembly
Start Date: 3/28/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/31/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: UMF Date: 17-3-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3589	C								

100 0.00
100
Large Fab
Large Fab
Memo 2.48
1- Form D3589-11, assemble and weld D3589-9 to D3589-11 as per dwg D3589
2- grind weld flush as per dwg D3589
3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589
*** ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS***
4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004
ensure parts fit correctly on jig
A/R Stainless Steel Rod Batch: M134442

2 EL / 17-3-30

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
QC Memo 0.00
Quality Control

② 17-03-31 DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location St 219	0.00				2			DAS 41 9-89
150									
Packaging	Memo	0.02							
Packaging									MAR 31 2017
160	QC21- Final Inspection - Work Order Release	0.00							
160									17/4/4
QC	Memo	0.20							DAS 21 9-89
Quality Control									

APR 03 2017

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

Page 1

Friday, March 24, 2017 11:06:45 AM

Work Order ID: 158515

158515

Parent Item: D3589-041

D3589-041

Parent Item Name: Latch Assembly

Start Date: 3/28/2017

Required Date: 3/31/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-06-05 DD verified by:ec IPP RevB: revise process as per coss DD 10.01.18 verified by:EC IPP REV:C 12.07.23 AS PER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3589-1		Manufactured	No			100	Each	11.0000	1	2			
D3589-1									**			<u>EL 17-3-29</u>	
Arm													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				11					
				146025				1					
				146938				4					
				157000				6					
D3589-11		Manufactured	No			100	Each	9.0000	1	2			
D3589-11									**			<u>EL 17-3-29</u>	
Fwd Guide Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				9					
				145405				3					
				149503				6					
D3589-13		Manufactured	No			100	Each	16.0000	2	4			
D3589-13									**			<u>EL 17-3-29</u>	
Lug													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				16					
				139003				10					
				156971				6					

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Page 2

Work Order ID: 158515

158515

Parent Item: D3589-041

D3589-041

Parent Item Name: Latch Assembly

Start Date: 3/28/2017

Required Date: 3/31/2017

Start Qty: 2.00

Required Qty: 2.00

D3589-15

Manufactured No

130 Each

15.0000 2 4

D3589-15

Link

**

FF

MAR 31 2017

MAR 31 2017

Location

Loc Qty

Loc Code

WA002

15

137716

1

148391

14

D3589-23

Manufactured No

100 Each

16.0000 2 4

D3589-23

Arm Guide

**

EL 17-3-29

Location

Loc Qty

Loc Code

WA002

16

146760

16

D3589-3

Manufactured No

130 Each

21.0000 2 4

D3589-3

Arm Guide

**

EL 17-3-29

Location

Loc Qty

Loc Code

WA002

21

147319

21

D3589-7

Manufactured No

100 Each

17.0000 1 2

D3589-7

Aft Guide Plate

**

EL 17-3-29

Location

Loc Qty

Loc Code

WA002

17

146811

3

147348

14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Page 3

Work Order ID: 158515

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Parent Item: D3589-041

D3589-041

Parent Item Name: Latch Assembly

Start Date: 3/28/2017

Required Date: 3/31/2017

Start Qty: 2.00

Required Qty: 2.00

D3589-9 Manufactured No

100 Each 9.0000 1 2

D3589-9

Fwd Guide Plate

**

Q 17-3-29

Location

Loc Qty

Loc Code

WA002

9

145706

9

2

MS20392-1C7 Purchased No

130 Each 70.0000 2 4

MS20392-1C7

Pin

**

FF

MAR 31 2017

Location

Loc Qty

Loc Code

ST314

70

m134488

70

4

MS24665-1010 Purchased No

130 Each 162.0000 2 4

MS24665-1010

COTTER PIN

**

FF

MAR 31

Location

Loc Qty

Loc Code

ST288

162

108335

162

4

NAS1149DN432J Purchased No

130 Each 126.0000 4 8

NAS1149DN432.J

WASHER

**

FF

MAR 31 2017

Location

Loc Qty

Loc Code

ST265

126

m129682

126

8

DQA: _____ Date: _____

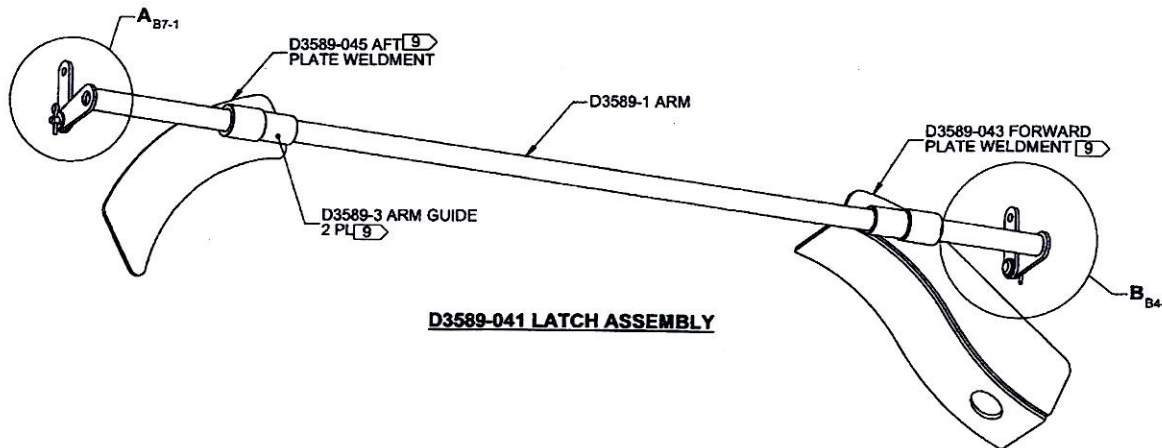


WORK ORDER NON-CONFORMANCE / UPDATE

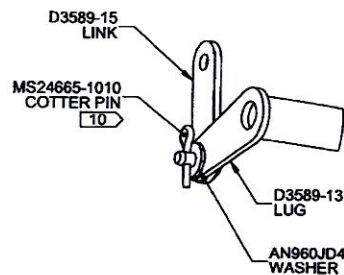
QA Closed: _____ Date: _____

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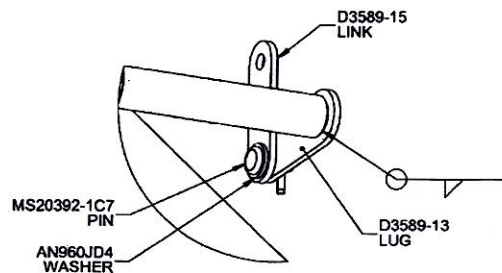
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OTHER :					



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL D8-1
SCALE 2X
2 PL



DETAIL B: WELDING AND LINK ASSEMBLY DETAIL C3-1
SCALE 2X
2 PL

ITEM	QTY. -041	P/N	DESCRIPTION
	X	D3589-041	LATCH ASSEMBLY
1	1	D3589-043	FORWARD PLATE WELDMENT
2	1	D3589-045	AFT PLATE WELDMENT
3	1	D3589-1	ARM
4	2	D3589-3	ARM GUIDE
5	2	D3589-13	LUG
6	2	D3589-15	LINK
7	4	AN960JD4	WASHER
8	2	MS20392-1C7	PIN
9	2	MS24665-1010	COTTER PIN

RELEASED
2012-07-16

C	REVISED D3589-5: 2.75 WAS 3.00 (ZN B6-4); ADDED D3589-21 (ZN B3-4); AFFECTS D3589-047 (ZN A7-3) AND D3589-049 (ZN A3-3). REVISED D3589-15: Ø0.140 WAS Ø0.129 (ZN B4-7). 0.900 WAS 1.150 (ZN C4-7); ADDED D3589-23 (ZN C3-4); AFFECTS D3589-043-045 (ZN D7-2 AND D2-2). REASON: PAR12-177.	MB	12.07.04
B	0.90 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.07.04		

- D3589-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
 - 7) WEIGHT: 0.75 lbs
 - 8) WELDING: PER DART QSI 004 USING DT9033
 - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
 - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3589

TITLE
LATCH ASSEMBLY

REV. C
SHEET 1 OF 8

SCALE
NTS

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								